

Work Order ID 119702

Friday, May 16, 2014 11:24:07 AM

119702

Page 1

Item ID: D3882-1-130

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Extrusion "I" Beam

Stop ***NS2***

Start Date: 6/6/2014 Start Qty: 75.00

75

Cust Item ID:

Required Date: 6/6/2014 Req'd Qty: 75.00

75

Customer:

Reference:

Approvals:

Process Plan: CLDate: 14/05/16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3882	Rev A								

100

0.00

100

Purchasing

Purchasing

Memo

PURCHASING

Issue P/O: 24269

a) Extrude as per Dwg D3882

b) Material: 6061-T6 (QQ-A-200/8) OR ASTM B221

c) Minimum yield tensile strength = 35 ksi

d) Minimum ultimate tensile strength = 38 ksi

e) Minimum elongation = 8%

f) Order at 130" long

g) Bon L Canada Inc. tool #DAA-6

H Pull test to ASTM standard B221 required.

J) Material certification is required

***EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE
SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH
AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS,
OR DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

CL 14/05/20 63

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Friday, May 16, 2014 11:24:07 AM

Page 2

Packaging

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Offset/Setup									
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FAULT CATEGORY

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Page 3

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Cust Item ID:

Required Date: 6/6/2014 Req'd Qty: 75.00

75

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 14-06-24

14-06-24

DQA: _____ Date: _____



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Material									
Operator									
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Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY




Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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- A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES

- CL13DS114
W/O: 119702

RELEASE
09/07/15

A	NEW ISSUE	RF	09.01.23
REV.		DESCRIPTION	BY DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3882 TITLE EXTRUSION	REV. /
DRAWN	RF		SHEET 1 OF
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
DATE	09.01.23	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. THIS IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN APPROVAL FROM DART AEROSPACE USA, INC.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24269**

Purchase Order Date 5/20/2014

PO Print Date 5/20/2014

Page Number 1 of 1

Order From :

VC-BON001

SIGNATURE ALUMINUM CANADA INC.
C/O/ T10322C
P.O. BOX 4488, STN A
TORONTO, ON M5W 4H1
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
5/24/2014

Contact Name

Vendor Phone 905-427-6550

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3882-1-130P EXTRUDE A SPER DWG D3882 REV (A B119702) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS.***	EXTRUSION	6/13/2014 Yes 6/13/2014		63.00 Each	\$53.56	\$3,374.41

Line Total: \$3,374.41

PO Total: \$3,374.41

CL

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 5/20/2014



**signature
aluminum
CANADA INC.**

1850 Clements Road, Pickering Ontario, Canada L1W 3R8

Phone: (866) 587-5780 Fax: (905) 427-2207

Visit us at www.signaturealum.com

INVOICING AND COMPANY LOCATION

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD

PICKERING ON L1W 3R8

PACKING LIST

ACCT# 46024

SHIP TO / EXPÉDIÉ À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

SOLD TO / VENDUE À

DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

PHONE: 613-632-5200

TERMS / FREIGHT

PP

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE

REFEREZ-VOUS A CES
NUMEROUS POUR TOUTE
CORRESPONDANCE

PACKING LIST DATE / DATE DU BODEREAU

06-17-14

PACKING LIST NUMBER / N° DE BODEREAU

015585

SALES ORDER NUMBER / N° DE COM

114425

LOCATION

PIC

TRAILER NUMBER /
REMORQUE Nombre

WILRIDE

SALESMAN /
VENDEUR

042

CREDIT REP / REP DU CRÉDIT

FIELD SALES REP / REP
REGIONAL DES VENTES

G.ATTENBOROU

SALES REP / REP. DES
VENTES

R. BLAIS

CUST SERVICE REP / REP.
SERVICE CLIENTELE

D1B

CUSTOMER ID / ID DU
CLIENT

46024

ORDER DATE / DE LA
COM

05/21/14

CUSTOMER PO NUMBER / CLIENT PO Nombre

PO24269

BILL OF LADING NUMBER / NO. DE CONNAISSEMENT

015585

JOB / FICHIER

CARRIER / TRANSPORTEUR
WILRIDE

ITEM
NO. /
NUMÉRO

ORIGINAL ORDER
QUANTITY /
Quantité d'ordre ORIGINAL

UNIT /
UNITÉ

PREVIOUS
SHIPPED QUANTITY /
PRÉCÉDENT
Quantité livrée

MFG. PART NUMBER /
MFG. PARTIE NUMÉRO

CUSTOMER PART NUMBER /
NUMÉRO DE RÉFÉRENCE DU CLIENT

ALLOY & TEMPER /
ALLIAGE & TEMPER

LENGTH / LONGUEUR

CUTTING TOLERANCE /
Tolérance de coupe

FINISH DESCRIPTION / DESCRIPTION DE FINITION

FABRICATION DESCRIPTION / DESCRIPTION DE FABRICATION

SHIPPING TOLERANCE / EXPÉDITION TOLERANCE

NBR OF
PKGS /
NBR DE
PKGS

GROSS LBS /
LIVRES BRUT

NET QUANTITY
/ QUANTITÉ
NETTE

UNIT /
UNITÉ

QUANTITY
DUE /
Quantité en
raison

001

1,106 LB

502 KG

63 PC

DAA-6-1

D3882-1

6061 T6

130.0000 IN

Cut(+): 0.1180 Cut(-): 0.0000

Min: -10 % Max: 10 %

1

1,071

486

1,054

478 KG

63 PC

LB

836120 / 216122

1

1,071

1,054

63 PC

DAS

27

3-89

14/02/24

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

Page 1

DATE OF DELIVERY

DRIVER

1	1,071	1,054	LB
	486	478	KG
		63	PC
TOTALS			

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
06/10/2014	5329482	114425	1
Cust PO	B/L No	Lot	Date
PO24269	015585	836120	06/17/14

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-6-1	130" MILL 6061 T6	D3882-1
Gross Weight	1,071 LBS		
Net Qty	1,054 LBS	63 PCS	1 PKGS
Specification	Die Desc		
ASTM B221-08			

Mechanical Tests:

Tensile	Yield	% Elongation	Conductivity	HRE
MPA / KSI	MPA / KSI			
298.7 / 43.3	269.7 / 39.1	11.5	N/A	92

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.65	0.27	0.21	0.06	0.90	0.05	0.09	0.02	0.01

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D3882-1-130
 DATE: June 24 / 2014

PO / BATCH NO.: 24269

MATERIAL CERT REC'D: Yes
 QUANTITY RECEIVED: 63
 QUANTITY INSPECTED: 12
 QUANTITY REJECTED: 0

THICKNESS ORDERED: 0.100
 THICKNESS RECEIVED: 0.108
 SHEET SIZE ORDERED: 130"
 SHEET SIZE RECEIVED: 130"

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	(N)	
CORRECT FINISH	(Y)	N	
CORROSION	Y	(N)	
CORRECT GRAIN DIRECTION	(Y)	N	
CORRECT MATERIAL	(Y)	N	
CORRECT THICKNESS	(Y)	N	
PHOTO REQUIRED	Y	(N)	
CORRECT MATERIAL	(Y)	N	
CORRECT REF # TO LINK CERT	(Y)	N	ASTM B221-08
CORRECT MATERIAL IDENTIFICATION	(Y)	N	
CORRECT M# ON THE MATERIAL	(Y)	N	836120 / 216122
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	(N)	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	(N)	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL SIZE OF TEST SAMPLE HARDNESS / DUROMETER READING	HRC	HRB	DUR A	DUR D	

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u> <u>27</u> DATE: <u>14/07/24</u>	SIGNED OFF BY: _____ DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

MATERIAL RECEIPT INSPECTION FORM

INSTRUCTIONS FOR INSPECTING BAR, TUBING, ROUND, & SHEET STOCK

- 1- VERIFY STOCK TO DART PURCHASE ORDER
- 2- MEASURE ALL DIMENSIONS FOR EACH PURCHASED STOCK
 - a. WIDTH, THICKNESS, DIAMETER, WALL THICKNESS & LENGTH
- 3- VERIFY CONDITION OF MATERIAL i.e. DAMAGED, CORRODED, etc.
- 4- VERIFY THAT SUPPLIER HAS A NUMBER (HEAT #) ON ITS RECEIVING REPORT TO LINK TO MATERIAL CERTS
- 5- VERIFY MATERIAL CERTS ARE CORRECT TO THE DART PO INSTRUCTIONS
- 6- REMOVE / CUT A PIECE OF MATERIAL FOR SAMPLE HARDNESS TESTING

INSTRUCTIONS FOR INSPECTING SKIDTUBE & STEP EXTRUSION

- 1- VERIFY TO DART SUPPLIED DRAWING
- 2- SAMPLE INSPECT MATERIAL IN BUNDLE TO ENSURE MATERIAL CAN BE RECEIVED INTO DART
- 3- USING PORTABLE HARDNESS TESTER VERIFY HARDNESS OF THE MATERIAL TO THE DRAWING
- 4- VERIFY THAT MATERIAL CERTS MATCH TO WHATS CALLED UP ON THE DART DRAWING

AFTER MATERIAL PASSES INSPECTION

- 5- HAVE DART EMPLOYEES START STOCKING MATERIAL BUT REQUEST MIN 20pcs FOR FULL INSPECTION
- 6- INSPECT ALL DIMS AS PER DRAWING REQUIREMENTS

INSTRUCTIONS FOR INSPECTING CROSS TUBE MATERIAL

- 1- VERIFY MATERIAL CERTS MATCH THE REQUIREMENTS ON THE DART DRAWINGS
- 2- INSPECT MIN. HALF THE BATCH OF EXTRUSION RECEIVED INTO DART
- 3- INSPECT MATERIAL AS PER THE EXTRUSION REPORT
 - a. WALL THICKNESS USING ULTRA-SONIC IN 4 LOCATIONS
 - b. OUTSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - c. INSIDE DIAMETER HIGHEST/LOWEST BOTH ENDS
 - d. STRAIGHTNESS @ CENTER OVER 12" SPAN
 - e. WALL THICKNESS USING TUBE MICROMETER HIGHEST/LOWEST BOTH ENDS
- 4- IDENTIFY EACH TUBE IN SEQUENCE OF INSPECTING (TUBE 1, TUBE2.....) AND W/O# AND PO#
- 5- RECORD ALL FINDINGS ON EXTRUSION REPORT

IF ANY QUESTIONS PLEASE SEE QC COORDINATOR BEFORE GOING FURTHER